

52

DART AEROSPACE LTD	Work Order:	22029
Description: Window Assembly	Part Number:	D3136-041
04.06.09		
Dwg: D3136 Rev. B C	Qty:	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	04.12.08	20
2	PG	Issue P/O: 7007273 Order D3136-1 per Dwg D3136 Supplier: -Canus Material: Polycast II Clear Acrylic sheet per MIL-P-5425 0.125" thick Apply 3M Protective Masking Film both sides Material release note required	U	04.12.09	20
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	05/01/03	20
4	QC6	Inspect dimensions as per Dwg D3136	U	05-01-03	20
5	GA	Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows. D3108-9 Batch: B20476	ml	05-01-07	20
6	GA	Engrave Part number and Batch number as per Dwg D3136	ml	05-01-07	20
7	QC5	Inspect work to Step 6	B	05-01-11	20
8	ST	Identify and Stock as D3136-041	CL	05/01/12	20
9	AC	Cost / part 56.88	595	05-01-13	20
10	DC	Close W/O 56.89 Inspect Level 21	HA	05.01.14	20

Rev	Date	Change	Revised By	Approved
A	03.11.28	New issue	KJ/DS	
B	04.02.04	Reformat	KJ/DS	

RELEASED
04.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

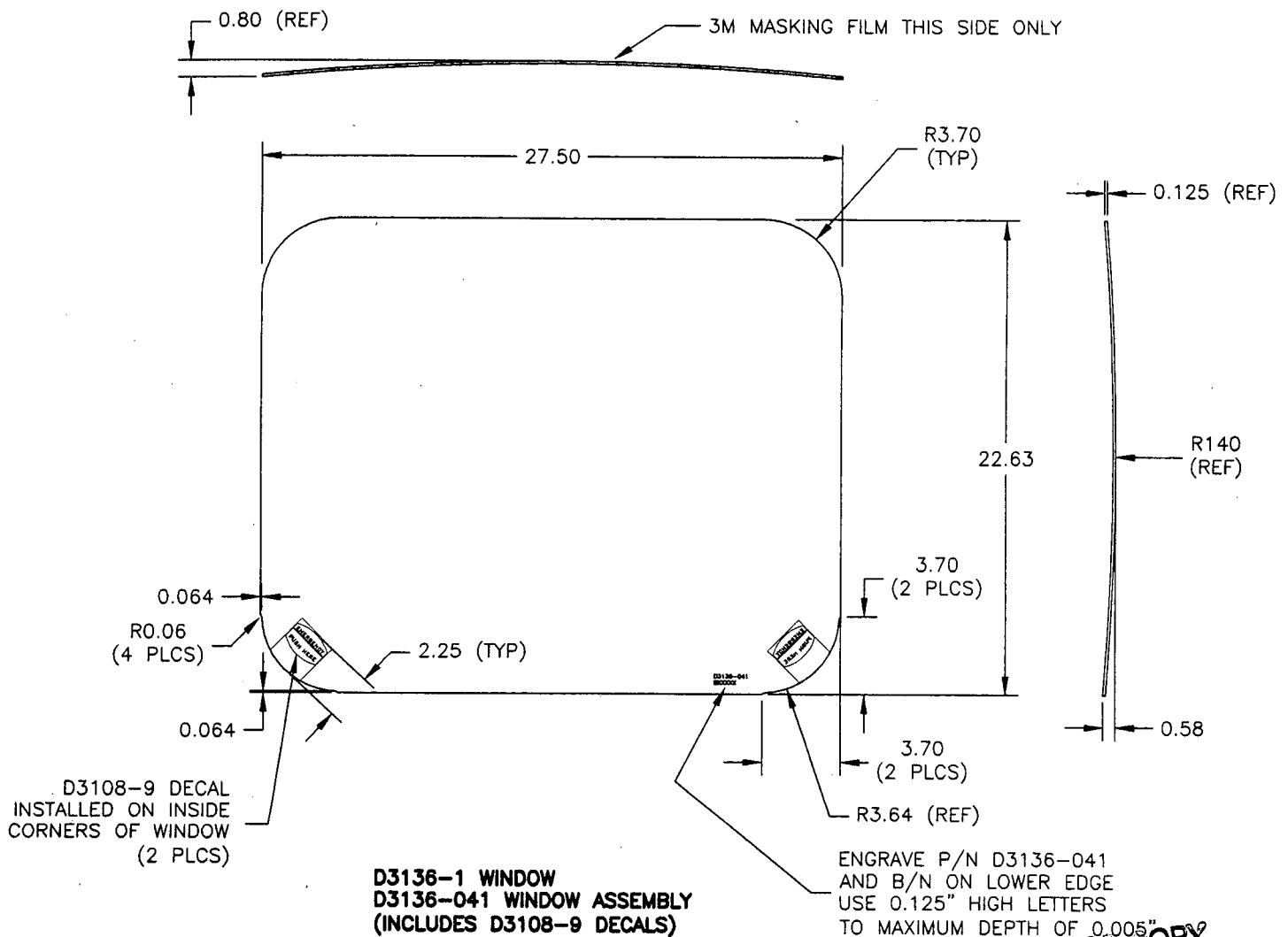
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3136
DATE	04.05.05	TITLE	WINDOW ASSEMBLY	REV. C SHEET 1 OF 2 SCALE 1:8
A	02.04.18	NEW ISSUE		
B	04.01.21	ADDED D3136-3 AND D3136-043		
C	04.05.05	ADDED FORMING & ENGRAVING SPEC		

RELEASED
04.05.12 *[Signature]*



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 22029

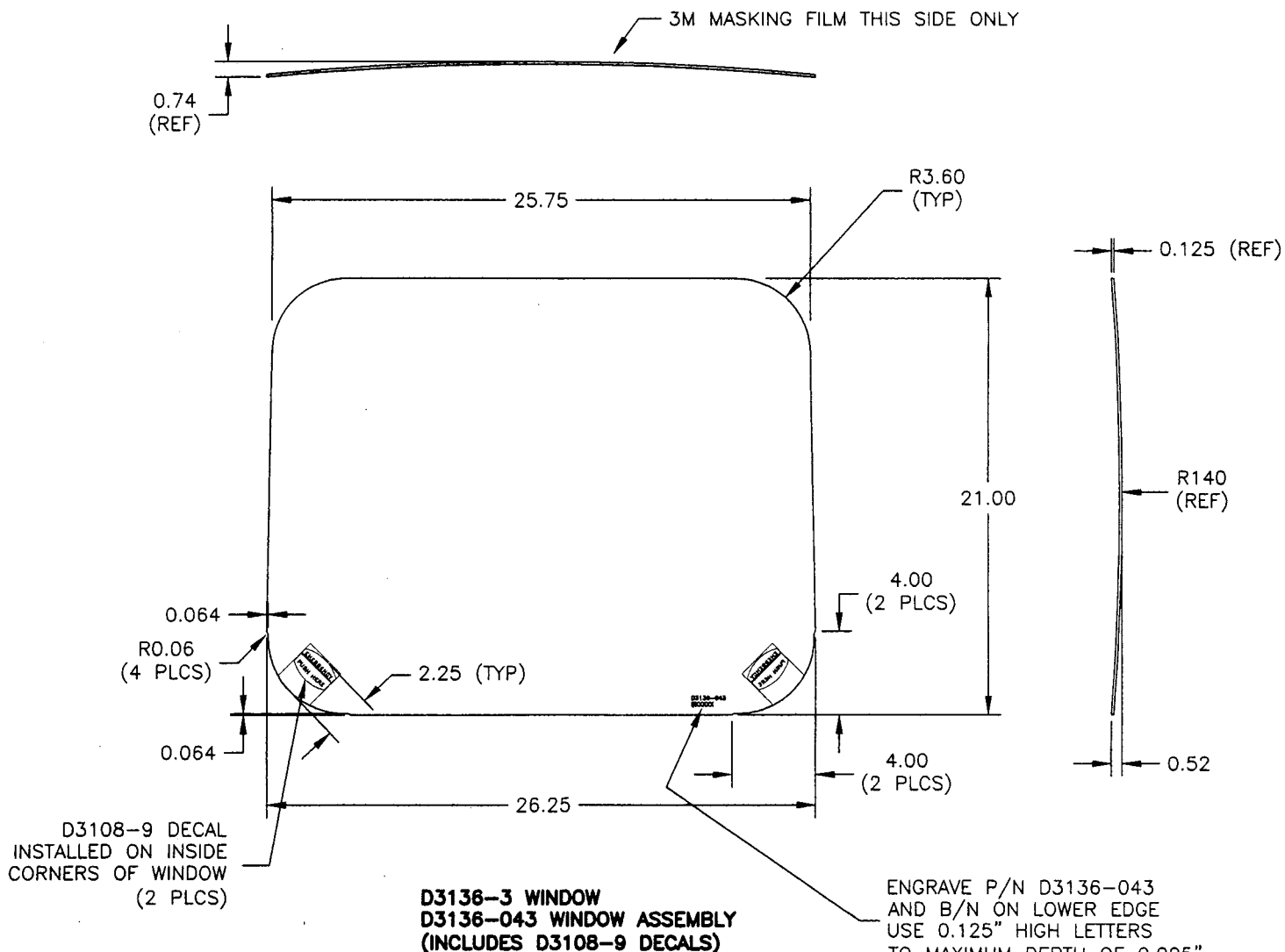
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3136	REV. C SHEET 2 OF 2
DATE 04.05.05		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED
04.05.12



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS:
 - a) HEAT LARGER PIECE TO 250° F
 - b) DRAPE OVER D3136-T1 MOLD & CLAMP
 - c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
 - d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 22029

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

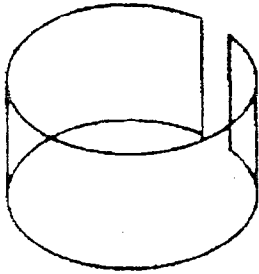
Dec 06, 2004
11:09 am

Work Order No	: 0022029	Department Code:	
Project Name	: D3136-041	Burden Flags	: NNNNNNNN
Project For	: WK452	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3136-041	Invoice Number	:
Description	: Window Assembly	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 20	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 12-03-04	Actual Margin	: 0.000%
Est Finish Date	: 12-21-04		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



CANUS Plastics Inc.
300 Lisgar Street,
Ottawa, Ontario, Canada
K2P 0E2
Telephone (613) 232-2657

CERTIFICATE OF CONFORMANCE

Attention: Receiving Inspection

TO Port Aerospace Ltd

Date: Dec 29/04
P.O # 2007273
Packing slip # 292004

The undersigned hereby certifies that the materials supplied and the items shipped herewith under the above purchase order and on the packing slip are in conformance with all contractual applicable government specifications and/or purchase order requirements and that physical and/or chemical reports of the materials supplied are on file and will be made available to the buyer and Government upon request.

QUANTITY

20

DESCRIPTION

Windows

SPECIFICATION #.

.D3136-1

CANUS PLASTICS INC.

[Signature]